



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4030-043

Job Sheet 171869



Part No: D4030-043

Job Qty: 1 ea

Part Name: Long Basket Assembly, Light Lid (350)



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/8/18

Job Tracking No:

Due Date: 2/27/18

Created By: Michelle Gagnon-Donovan

Type: SOLD

Description:

Note: DWG REV D SHEETS 2,3,4 IPP Rev:A new issue DD 10.03.23 verified by:EC IPP Rev:B as per dwg revB DD 10.04.20 verified by:EC IPP Rev:C added NAS1149F0332P & NAS1149C0432R 10.06.16 DD VERF:EC IPP Rev:D as per dwg revC DD 10.08.18 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		2/26/18	0.00	0.00	Start Up Stores/Pkg-1		
100	Packaging	1 pcs		2/26/18	0.00	0.00	Packaging1-4		
110	HandFinish	1 pcs		2/27/18	0.00	1.18	HandFinish4		
120	QC	1 pcs		2/27/18	0.00	0.00	QC5		
130	Packaging	1 pcs		2/27/18	0.00	0.00	Packaging3-2		
140	QC21-SA	1 Ea		2/27/18	0.00	0.00	QC21		

DAS
21
9-86

MAY 18 2018

P.T.O.

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Container No: S074731

Part: D4030-043

Job No: 171869

Serial No/Batch: S074731

Revision:
Inspector:

Date: 05/25/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-14A	Bolt	4 Ea (4 ea)	90-Start up Operation	5019387
AN3-20A	Bolt	2 Ea (2 ea)	90-Start up Operation	FM138081-76
AN310-4	Nut	3 Ea (3 ea)	90-Start up Operation	5019389
AN310C4	Nut	2 Ea (2 ea)	90-Start up Operation	5024835
AN4-12	Bolt	3 Ea (3 ea)	90-Start up Operation	5019372
AN5-17A	Bolt	2 Ea (2 ea)	90-Start up Operation	5019409
AN5-21A	Bolt	2 Ea (2 ea)	90-Start up Operation	FM13570.0
D2530	Handle Weldment	1 Ea (1 ea)	90-Start up Operation	5045607
D2535	Spring	2 Ea (2 ea)	90-Start up Operation	5042896
D2537	Bushing	2 Ea (2 ea)	90-Start up Operation	5043700
D3913-0415047350	Long Basket Base Assembly, 350	1 Ea (1 ea)	90-Start up Operation	5043509
D3915-0415046471	Light Lid Assembly, Long Basket	1 Ea (1 ea)	90-Start up Operation	5043534
D3917-3	Washer	6 Ea (6 ea)	90-Start up Operation	5064730
D3953-17	Gas Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5043161
D3953-19	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5049481
D3953-21	Gas Spring Bracket	1 Ea (1 ea)	90-Start up Operation	5048560
D3953-3	Gas Spring Stud, Lid	2 Ea (2 ea)	90-Start up Operation	5052077
D3953-7	Spring Spacer	2 Ea (2 ea)	90-Start up Operation	5048613
D3953-9	Gas Spring Washer	2 Ea (2 ea)	90-Start up Operation	5038764
D3969-3	Spring (Basket Lid) 5055080	1 Ea (1 ea)	90-Start up Operation	5016880
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	5027555
MS21042L5	Nut	4 Ea (4 ea)	90-Start up Operation	5015687
MS24665-151	Cotter Pin	3 Ea (3 ea)	90-Start up Operation	5025747
MS24665-300	Cotter Pin	2 Ea (2 ea)	90-Start up Operation	5040603
NAS1149C0432R	Washer	2 Ea (2 ea)	90-Start up Operation	5034412
NAS1149F0332P	Washer	8 Ea (8 ea)	90-Start up Operation	5032269
NAS1149F0432P	Washer	6 Ea (6 ea)	90-Start up Operation	
NAS1149F0563P	Washer	4 Ea (4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-14A	4	200	0
	AN3-20A	2	19	0
	AN310-4	3	109	0
	AN310C4	2	104	0
	AN4-12	3	143	0
	AN5-17A	2	139	0
	AN5-21A	2	45	0
	D2530	1	18	0
	D2535	2	37	0
	D2537	2	24	0
	D3913-041	1	2	0
	D3915-041	1	0	0
	D3917-3	6	63	0
	D3953-17	2	23	0
	D3953-19	1	6	0
	D3953-21	1	14	0
	D3953-3	2	21	0
	D3953-7	2	40	0
	D3953-9	2	44	0
	D3969-3	1	21	0
	MS21042L3	6	3,757	0
	MS21042L5	4	497	0
	MS24665-151	3	160	0
	MS24665-300	2	76	0
	NAS1149C0432R	2	1,653	0
	NAS1149F0332P	8	3,827	0
	NAS1149F0432P	6	1,592	0
	NAS1149F0563P	4	233	0

Part Specifications

Specifications could not be found.

DQA: DAS 53 9-89 Date: JUN 28 2018 **WORK ORDER NON-CONFORMANCE / UPDATE**



QA Closed: 9-89 Date: JUN 28 2018 Work Order update only ☐

Work Order: <u>171862</u> Part No. <u>D4050-045</u> NCR No. <u>18-6901</u>	DISPOSITION		AGAINST DEPARTMENT/PROCESS					
	Rework ☒	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒			
	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐			
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐			
	Suspected Unapproved ☐	Large Fab ☐	Composite ☐	Supplier ☐				

Date: <u>18-05-25</u>	Step #: <u>90</u>	QTY Effective: <u>①</u>	MRB (QSI042) Approval DAS 12 9-89 <u>18/6/26</u>
-----------------------	-------------------	-------------------------	---

Description Work Order Deviation	Disposition	
Issue found when int installing D4029-041	Acceptable to remove D4029-5 and install D4029-041 as per Rev A.	Completed By DAS 12 9-89 <u>18/6/26</u>
Fitting issue found	See attach email	Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>18-05-25</u>
		QC / QA Coordinator Approval DAS 9 9-89 <u>18-05-25</u>

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☒	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	☒ Fit/Function	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER: ☐			
Misidentified ☐	Past Due ☐				

Chris Provencal

From: David Shepherd
Sent: Thursday, May 24, 2018 2:05 AM
To: Ryan Williamson; Chris Provencal; Linda Lacelle; Harvey Siemens
Cc: Jason Leroux; Eric Downing; Patrick Lussier; Patrick Duval; Lacey Cantin; Robert Aboud
Subject: RE: NCR D4029-041 Webbing
Attachments: D4029-RevA.PDF

Chris,

We added the mesh backing at Rev B to improve safety. From what I gather from the email trail below, the new mesh backing is creating issues. Since we are in an absolute panic to get the basket out of the building, I would be OK (on a one time only basis) with manufacturing the D4029-041 lid per D4029 Rev A (attached), which, to my knowledge, did not create any issues with manufacturing. Just throwing that suggestion out there in case it helps.

Harvey,

When we made this change, we should have had a prototype made to validate the design change. I'm not saying that I would have anticipated these problems either, but webbing and mesh do not behave like aluminum and steel. Something to think about for the future.

Regards,
David

From: Ryan Williamson
Sent: May 23, 2018 3:47 PM
To: Chris Provencal <cprovencal@dartaero.com>; Linda Lacelle <llacelle@dartaero.com>; Harvey Siemens <hsiemens@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>; David Shepherd <dshepherd@dartaero.com>; Eric Downing <edowning@dartaero.com>; Patrick Lussier <plussier@dartaero.com>; Patrick Duval <pduval@dartaero.com>; Lacey Cantin <lcantin@dartaero.com>; Robert Aboud <raboud@dartaero.com>
Subject: Re: NCR D4029-041 Webbing

Harvey,

Can you have someone jump on this ASAP? This has been lingering somewhat and there is a customer getting angry. Would like to get resolution on this.

Thanks,
Ryan

From: Chris Provencal <cprovencal@dartaero.com>
Date: Wednesday, May 23, 2018 at 4:38 PM
To: Linda Lacelle <llacelle@dartaero.com>, Ryan Williamson <rwilliamson@dartaero.com>, Harvey Siemens <hsiemens@dartaero.com>
Cc: Jason Leroux <jleroux@dartaero.com>, David Shepherd <dshepherd@dartaero.com>, Eric Downing <edowning@dartaero.com>, Patrick Lussier <plussier@dartaero.com>, Patrick Duval <pduval@dartaero.com>, Lacey Cantin <lcantin@dartaero.com>, Robert Aboud <raboud@dartaero.com>
Subject: RE: NCR D4029-041 Webbing